

1/5

Date: Tuesday, 01/04/2008 3:46:53 PM
User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	5-MAN FACING HARNESS
Job Number :	38281		
Estimate Number :	12331		
P.O. Number :		Part Number :	D214702035
This Issue :	01/04/2008	Drawing Number :	IIN-D412-702 PG11-12
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	//	Drawing Revision :	E E
Previous Run :	26201	Material :	
Written By :		Due Date :	02/05/2008
Checked & Approved By :	JLD 08.4.01	Qty:	2 Um: Each
Comment :	Esat Rev:A New Issue 06-03-10 JLM Est Rev:B 07-03-14 As per DSI 9351 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
Comment: Photocopy bluefile & type labels per PPPD204-702-035 CHG001 08/04/28 08/4/14 JLD		
2.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Pick Packing Kit		
3.0	D3446045	214 harness
Comment: Qty.: 5.0000 Each(s)/Unit Total: 10.0000 Each(s) Pick Packing Kit Qty Part Number Description Batch 5 D3446-045 214 harness 38235		
skhroth (2) Batch Not in comp yet AS 08/04/25 (x2)		
4.0	D355111	HOOK AND LOOP TIE
Comment: Qty.: 5.0000 Each(s)/Unit Total: 10.0000 Each(s) CLIP BATCH: B31217		
AS 08/04/17 (x2)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 5-MAN FACING HARNESS

Job Number: 38281

Part Number: D214702035

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

5 08/04/28 (x2)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D204-702-035

Location: _____

PPP Rev: _____

A

8/1/28

sep

(2)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/29

Job Completion



mf 08-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

3.5 Installation of the Dart 1-Man Forward Facing Shoulder Harness Kits (D412-702-019/-029)

Refer to **Figures 1.2, 3.3, 3.4, 3.5A, and 3.5B** for the -019/-029 installations.

- 3.5.1 For the D412-702-029 kit, remove the existing lap belts.
- 3.5.2 Position qty (2) D3215-041 Harness Assemblies (-019) or qty (1) D3446-041 Harness Assembly (-029) on the D3196-1 Bar as shown in **Figure 3.3** (the two outboard belts shown in **Figure 3.3** will not be present in the 1-Man kit). Locate the D3196-1 Bar on the central panel at WL 53.5.
- 3.5.3 Optional – Install the D3551-11 hook and loop ties through the front loops of the shoulder belt as shown in **Figure 3.4**. If using the hook and loop ties, position the D3546-1 Clips as shown in **Figure 3.4**.
- 3.5.4 Fasten the bar to existing nutplates (BL 8.96) over the OEM thermal blanket using MS24694-S152 or MS24694-S154 screws to fit; substitute with other MS24694 screws if required to ensure proper thread engagement in the nutplates. To pass through the thermal blanket, either cut holes and reinforce the blanket or install D3619-2 grommets from the D412-702-069 Grommet Kit per Section 5.0 of this IIN. It is acceptable to relieve the pads on the back of the D3196-1 Bars to clear rivets in existing structure. Install the bar on top of the thermal blankets. Torque the screws to 100-140 in-lbs (11.3-15.8 Nm).
- 3.5.5 For the -019 kit, attach the bottom loops of the shoulder belts to the lap belts as shown in **Figure 3.5A**. For the -029 kit, fasten the lap belt end fittings to the seat as shown in **Figure 3.5B** and, at the customer's option, secure the end fittings by using MS20995C41 lockwire per AC43.13-1B Chapter 7 Section 7 or install a MS24665 cotter pin.

3.6 Installation of the Dart 5-Man Aft Facing Shoulder Harness Kit for Bell 214B/B-1 (D214-702-035)

Refer to **Figures 3.5B and 3.8** for the -035 installation.

- 3.6.1 Remove the existing lap belts.
- 3.6.2 Position the D3445-045 Harness Assemblies on the 214-070-700-009 Seat Assembly of the Bell 205-706-010-001 Passenger Seat Kit as shown in **Figure 3.8**. The lap belts should attach to the 205-070-725-011 rings as shown in **Figure 3.5B**. The shoulder straps should loop around the back of the seat with the passenger's left and right shoulder belts crossing to form an 'X' on the back of the seats, and attach to the rings as shown in **Figure 3.5B**.
- 3.6.3 At the customer's option, secure the end fittings by using MS20995C41 lockwire per AC43.13-1B Chapter 7 Section 7 or install a MS24665 cotter pin.

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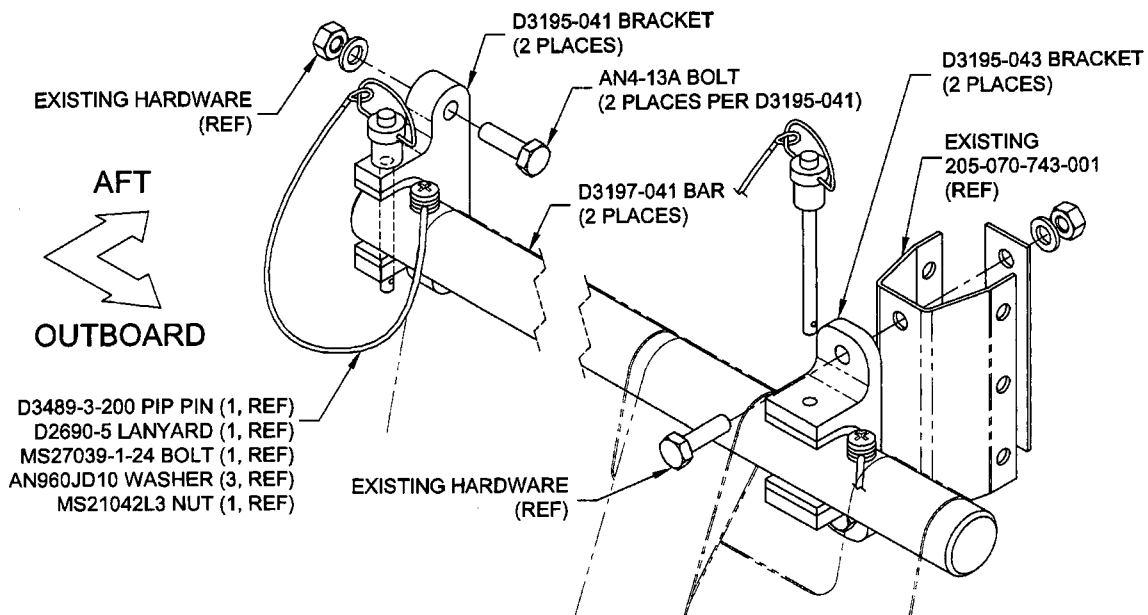


FIGURE 3.1. BRACKET AND BAR INSTALLATION
(D412-702-011/-013/-021/-023 KITS, LH SIDE SHOWN, RH OPPOSITE)

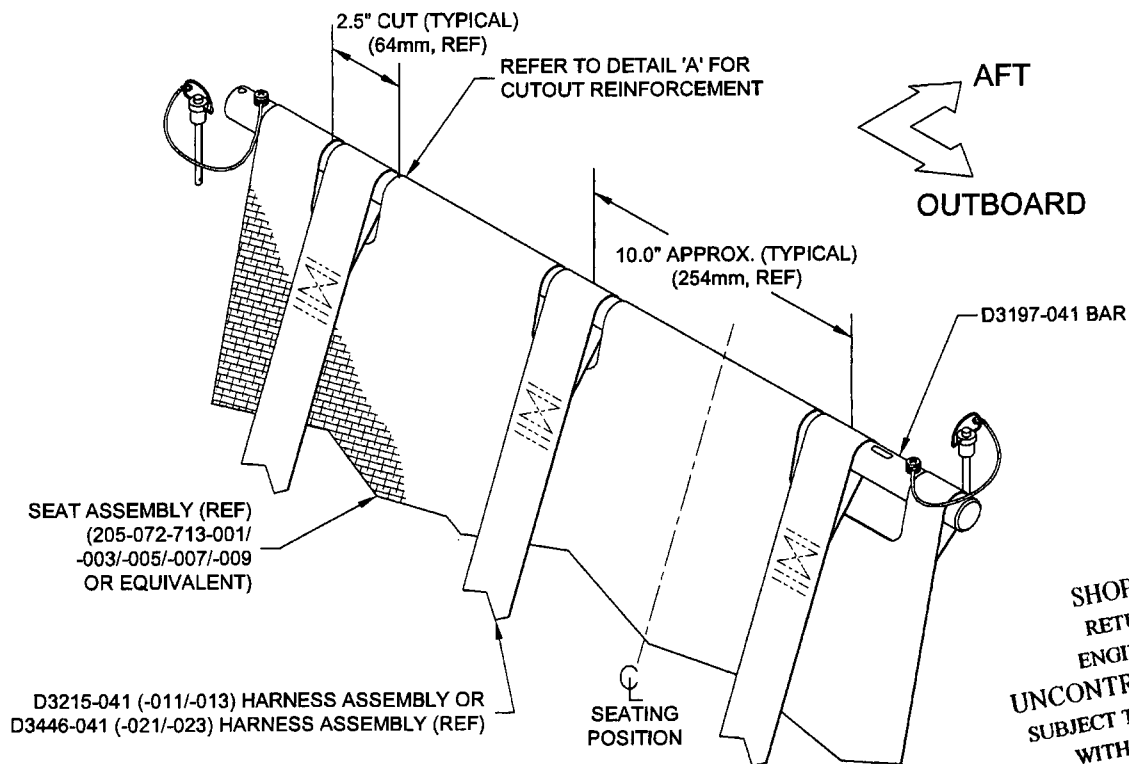


FIGURE 3.2. CANVAS MODIFICATION AND BELT INSTALLATION
(D412-702-011/-013/-021/-023 KITS, LH SIDE SHOWN, RH OPPOSITE)

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